TUBE STRAIGHT & PARALLEL TO 40643-3 THRU THIS DIMENSION

SWAGE $\frac{.942}{.946}$ I.D. FOR DISTANCE INDICATED

(-2) TUBE

(-6) BRACE

40631-4

40631-5

40631-3

40631-2

(-4) BRACE

(-5) BRACE

(-3) TUBE

(-7) SUB-ASSY.

SWAGE TO .756 MIN. I.D. FOR DISTANCE INDICATED

SEE FIG. 1

SEE NOTE 1

81232-3

AUG 1 1958

| | | |
|---|---|---|
| 84501-2 | DASH NO. ONLY | CHANNEL SECTION |
| 81232-3 | 1 | DISC |
| 80122-18 | 2 | WASHER |
| 80042-15 | 4 | PLATE |
| 80022-45 | 1 | BUSHING |
| 80022-22 | 4 | |
| 80012-5 | 1 | |
| 40631-5 | 1 | RIB |
| 40631-4 | 1 | |
| 40631-3 | 1 | |
| 40631-2 | 1 | |
| -7 | | SUB-ASSY. CONSISTS OF (1) 80012-5, 2 OF 80122-18 |
| -6 | 1 | 13 15/16 LONG |
| -5 | 1 | 15 9/16 LONG PIPER SECTION |
| -4 | 1 | 24 15/16 LONG |
| -3 | 1 | 7/8 x .058 x 54 3/4 |
| -2 | 1 | 1 x .028 x 64 |

| PART NO | NO. REQ. | SIZE | DESCRIPTION / MATERIAL |
|---|---|---|---|
| SCALE 4"=1 FT. & NOTED | | | TOTAL WT.-LBS. |
| FINISH—PIPER SPECIFICATION #10 | | | |
| MANUFACTURING PRACTICES—PIPER SPECIFICATION #3 | | | |

STABILIZER ASSEMBLY

| M.G.S. | L.E.L. | | |
|---|---|---|---|
| 4-22-43 | 7-1-43 | | 40644 |
| DRAFTSMAN | CHECKER | STANDARDS | |

.266 HOLE IN -3

80122-18

80012-5
.191 HOLE AFTER WELDING

SEE NOTE 3

FILE SMOOTH AFTER WELDING

.813

.750

80042-15

80022-22

80022-45 FORCED FIT INTO 80022-22

REAM $\frac{.249}{.251}$

FIG. 1
HINGE & TIE ROD FITTING DETAIL
FULL SIZE

NOTE:
1. HINGE CENTERS TO COINCIDE WITH THOSE ON 40572.
2. MAGNETIC INSPECTION REQUIRED.
3. FINISH WELD FLUSH WITH END OF HINGE BUSHINGS.

| LET. | REVISION | DATE | BY |
|---|---|---|---|
| V | IN B/M FOR -2 MATL. SPEC. REV. | 2-27-62 | GB |
| U | NOTE 3 ADDED | 4-17-62 | FWB |
| T | FOR -3 7/8 x .058 x 36 WAS 7/8 x .049 x 54 3/4 | 1-24-60 | GB |
| S | NOTE 2 ADDED | 9-28-54 | MM |
| R | 80122-20 REM. | 10-5-53 | IEM |
| Q | REDRAWN WITHOUT CHANGE | 6-19-51 | M.G. |
| P | -6, -9, -10, 10143-74, 86102-37 & 86102-38 REM'D. | 1-16-48 | JCB |
| O | -6, -9, -10, 10143-74, 86102-37 & 86102-38 ADDED | 1-16-48 | JCB |
| N | 4 EA. OF 80022-22 | 2-8-46 | DAH |
| M | 80012-15 REM. FROM -7 | 12-28-43 | MM |
| L | 945/950 WAS 946/950 | 1-7-44 | JBM |
| K | MAT'L SPEC. REV. FOR -2 | 12-7-43 | MM |
| J | NOTE REVISED | 8-12-43 | CEK |
| H | NOTES ADDED | 8-12-43 | CEK |
| G | 2 3/4 & 5 3/4 DIM'S ADDED | 4-22-43 | MGS |
| | REDRAWN & REVISED | | |

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| MODEL | PER PLANE | NEXT ASSEMBLY | SUPERSEDES | SUP. BY |
|---|---|---|---|---|
| PA-15 | 2 | 44652 | | |
| PA-15C | 2 | 44652 | | |
| PA-15S | 2 | 44652 | | |
| PA-15M | 2 | 44652 | | |

PIPER AIRCRAFT CORP.
LOCK HAVEN, PENNA.